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**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (Previously Presented) A method for manufacturing a pleated filter material from a thermally bonded non woven fabric, comprising :

forming a single fibrous web from undrawn and drawn synthetic fibers;

pre-heating the fibrous web;

calendering the single fibrous web between non-heated profiled calender rolls in a single calendering step without subsequent re-heating, wherein during the single calendering step, the undrawn fibers in the single fibrous web form bonds in a tension free manner between the non-heated profiled calender rolls to form the non woven fabric, wherein the bonds of the non woven fabric are of equal strength over its cross-section, wherein the non woven fabric is formed without the use of flat bonding, and wherein during the single calendering step, spacers are formed in the non woven fabric to thereby form the filter material.